

Date: Thursday, 1/17/2008 3:25:39 PM
 User: Kim Johnston

Process Sheet

Customer	CU-DAR001 Dart Helicopters Services		Drawing Name	JACK SADDLE	
Job Number	36824				
Estimate Number	11177				
P.O. Number			Part Number	D2281	
This Issue	1/17/2008	S.O. No.	Drawing Number	D2281 REV G	
Prsht Rev.	NC		Project Number	N/A	
First Issue	/ /	Type	Drawing Revision	G	
Previous Run	35471		Material		
Written By			Due Date	2/10/2008	
Checked & Approved By	<u>kgj080118</u>		Qty:	100	Um: Each
Comment	Est Rev:A Removed from 9 Digit 05-12-02 JLM		Est: rev B 06.07.17 waterjet EC		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	M304S14GA	304SS .080
Comment: Qty.: 0.1313 sf(s)/Unit Total : 13.1250 sf(s) 304SS .080 batch: <u>105112 HB 8-1-23</u>		
2.0	WATER JET	FLOW WATER JET
Comment: FLOW WATER JET 1-Cut as per Dwg D2281 Dwg Rev: <u>G</u> HB 8-1-23 Prog Rev: <u>G</u>		
2-Deburr if necessary HB 8-1-23		
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
Comment: INSPECT PARTS AS THEY COME OFF MACHINE HB 8-1-23		
4.0	QC8	SECOND CHECK
Comment: SECOND CHECK S.08.01.29		
5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
Comment: Deburr u/a Done at 8Feb 2008		

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA:  Date: 5/02/15
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 1/17/2008 3:25:39 PM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: JACK SADDLE

Job Number: 36824

Part Number: D2281

Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 BRAKE NC NC BRAKE



Comment: NC BRAKE

Form as per D2281 using D2281-T2

SB

08/02/14

76

7.0 QC5 INSPECT WORK TO CURRENT STEP



counts
08/02/14 (476)

Comment: INSPECT WORK TO CURRENT STEP

8.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: Done 15

1/2/15

76

9.0 QC21 FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/02/15

76

Job Completion



mi 2008/2/15

76

W

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	36824
Description: Jack Saddle	Part Number:	D2281
Inspection Dwg: D2281	Rev: G	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

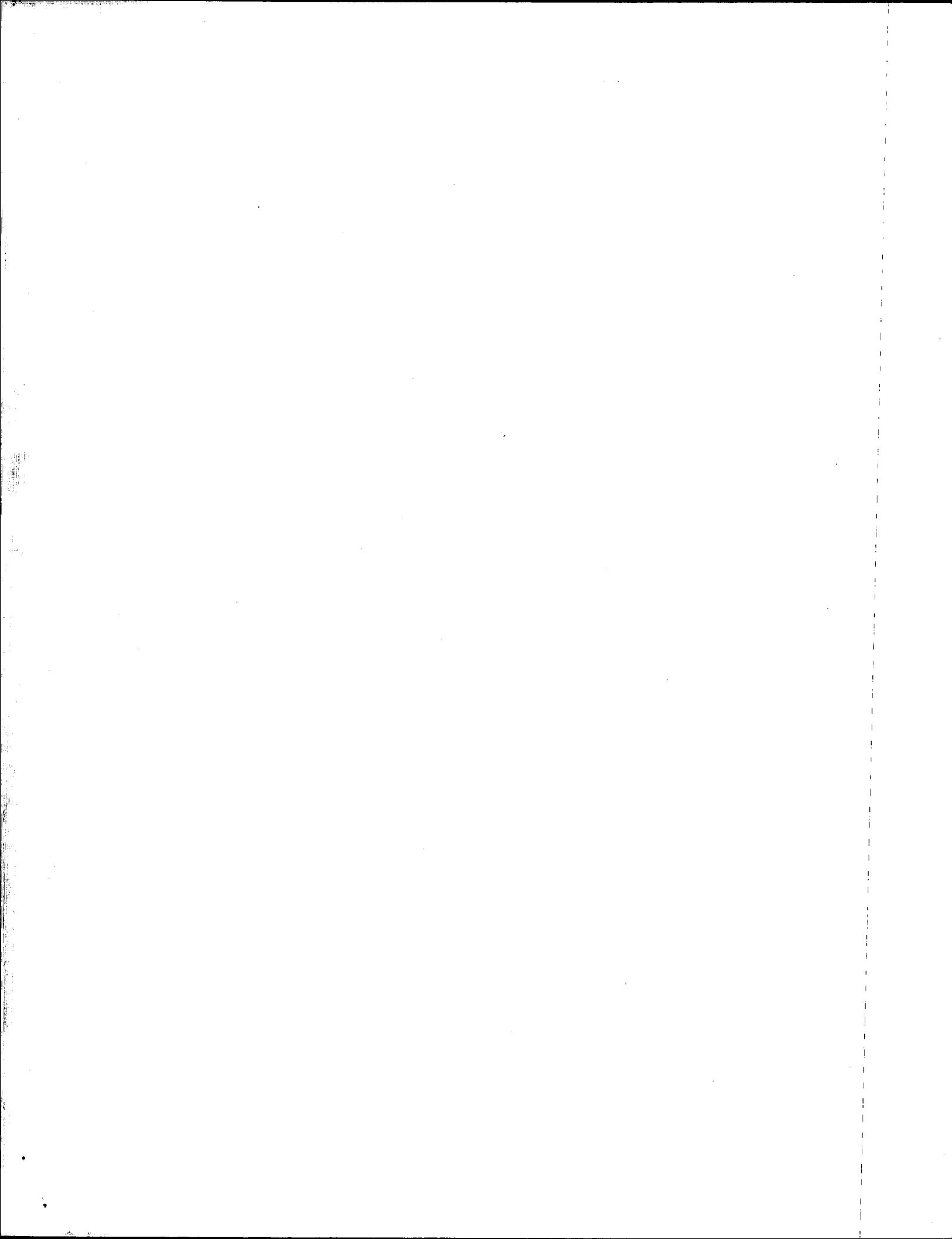
X First Article Prototype

Measured by:	FB
Date:	8-1-23

Audited by:	<i>[Signature]</i>
Date:	08/01/05

Prototype Approval:	N/A
Date:	N/A

Rev	Date	Change	Revised by	Approved
A	06.09.08	New Issue	KJ/JLM	JL



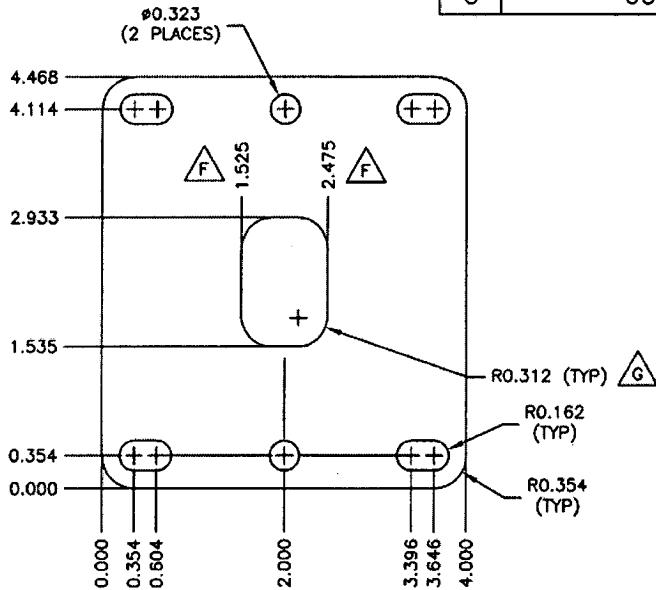


DESIGN BW	DRAWN BY <i>FB</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED <i>CP</i>	APPROVED <i>MHS</i>	DRAWING NO. D2281
DATE 05.06.07	TITLE JACK SADDLE	REV. G SHEET 1 OF 1 SCALE 1:2

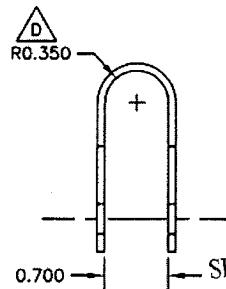
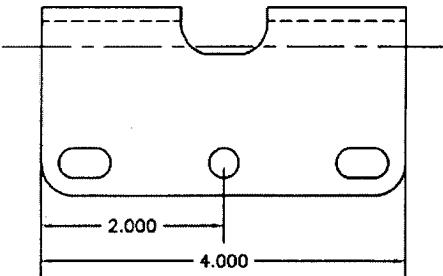
RELEASED

05/08/11

A	94.10.14	NEW ISSUE
B	94.10.18	DIMENSION WAS 2.878
C	94.11.04	ADD TOOLING NOTCH
D	98.03.27	R0.350 WAS R0.280
E	04.11.18	REMOVE TOOLING NOTCHES
F	05.03.16	REDESIGN FLAT PATTERN
G	05.06.07	REDESIGN FLAT PATTERN



FLAT LAYOUT



UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE

WORK ORDER
NO. *36824*

D2281 JACK SADDLE

- 1) MATERIAL: 304/316 SS, 0.080 THICK (REF DART SPEC. M304S14GA)
- 2) FINISH: NONE
- 3) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED